

Work Order ID 65921-2  
Thursday, January 27, 2011 10:47:15 AM

Item ID: D3916-041

Revision ID:

Item Name: Rib Assembly

Start Date: 1/27/2011 Start Qty: 6.00

Required Date: 2/4/2011 Req'd Qty: 6.00

Reference:

Approvals: Process Plan:

QC:

Date: 11-01-27 Tooling:

Date: SPC (Y/N):

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3916

A

100



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: 111585 0.00

Memo

0.00

1- Cut tube 50"

2- Bend tube with manuel pipe bender as per DT9567

\*\*\* Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending\*\*\*

3- Trim access tube material to finish size as per dwg D3916

4- Drill and chamfer holes as per dwg D3916-1 using DT9605

5- weld bushing as per dwg D3916

6- grind welds flush

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O 0.00

Memo

0.00

Silozis

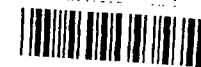
4x

14 4x  
CPL 11-02-15

SAD 11-02-03



Accept



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 65921

Thursday, January 27, 2011 10:47:15 AM

Page 2

Item ID: D3916-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Rib Assembly

Start Date: 1/27/2011 Start Qty: 6.00

Cust Item ID:

Required Date: 2/4/2011 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC10- Inspect visual per QSI004- ground welds

0.00

QC

Memo

Quality Control

130

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

Packaging

Memo

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

Quality Control



*Sublet*

*(X4)*

*11/02/15 (4x)*

*11/02/16 ME*

*11-02-15*

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, January 27, 2011 10:47:28 AM

Page 1

Work Order ID: 65921

Parent Item: D3916-041

Parent Item Name: Rib Assembly



Start Date: 1/27/2011

Required Date: 2/4/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC  
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1		Manufactured	No			100	Each	9.0000	7	42			
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Bushing

Location

Loc Qty

Loc Code

WA

9

54072

9

M304TS0.750W.049

Purchased

No

100

f

92.0831

4.166

26.31158

61.3938



304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

MAT

55.13726794

113763

0

114323

8.15031894

114677

0.00001

114835

0.000039

116319

25.1993

116509

21.7876

MAT017

3.68448E-05

114298

3.6845E-05

WA

36.9458

114992

11.0693

115260

25.8765

71116719

END BAR  
Sump

61.3938

3.000

61.3938

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

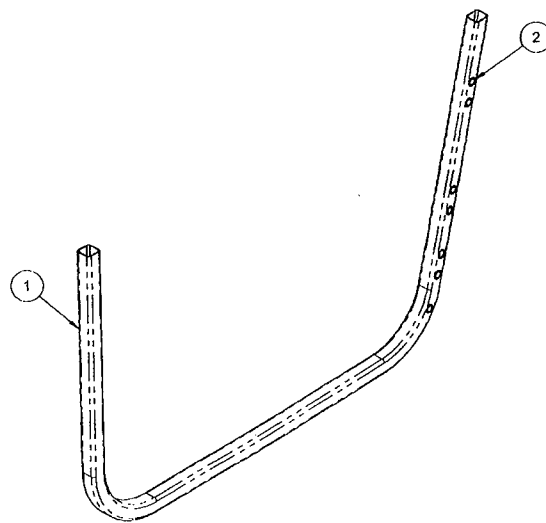
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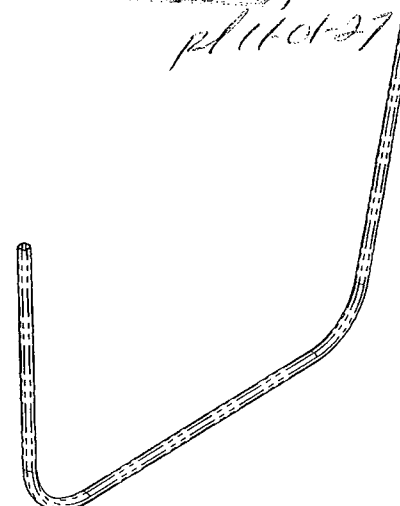
**NOTE:** Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING

SHEET 1 OF 4  
 RETURN TO:  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. *05921*  
*pl 11-01-27*



D3916-041 RIB ASSY



D3916-5 LIGHT RIB

OK *10.12.21*  
 UNDER REVIEW  
 10.10.10  
 ADDITION OF HOLE + BUSHING  
 ON D3916-041 RIBS.  
**RELEASED**  
 2010-03-12  
*JMP*

A		NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION	BY	DATE		
DESIGN	AJS				
DRAWN	JPH				
CHECKED	<i>[Signature]</i>				
MFG. APPR.	<i>[Signature]</i>				
APPROVED	<i>[Signature]</i>				
DE APPR.	<i>[Signature]</i>				
DATE	10.03.04				
DART AEROSPACE LTD					
HAWKESBURY, ONTARIO, CANADA					
DRAWING NO. D3916				REV. A	
TITLE RIB ASSY, 350 BASKET				SHEET 1 OF 4	
SCALE NTS					
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W/O:		WORK ORDER CHANGES						
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

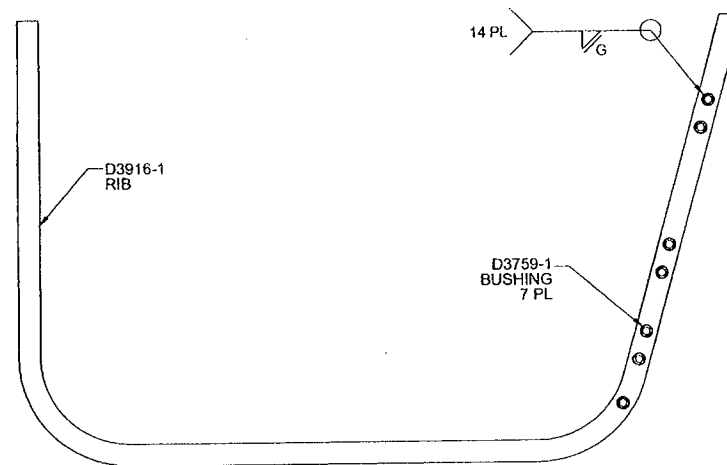
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**NOTE:** Date & initial all entries



u1065921



D3916-041 RIB ASSY

**RELEASED**  
2010-03-12  
AJP

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR DISCLOSED OR REPRODUCED TO ANY OTHER PERSONS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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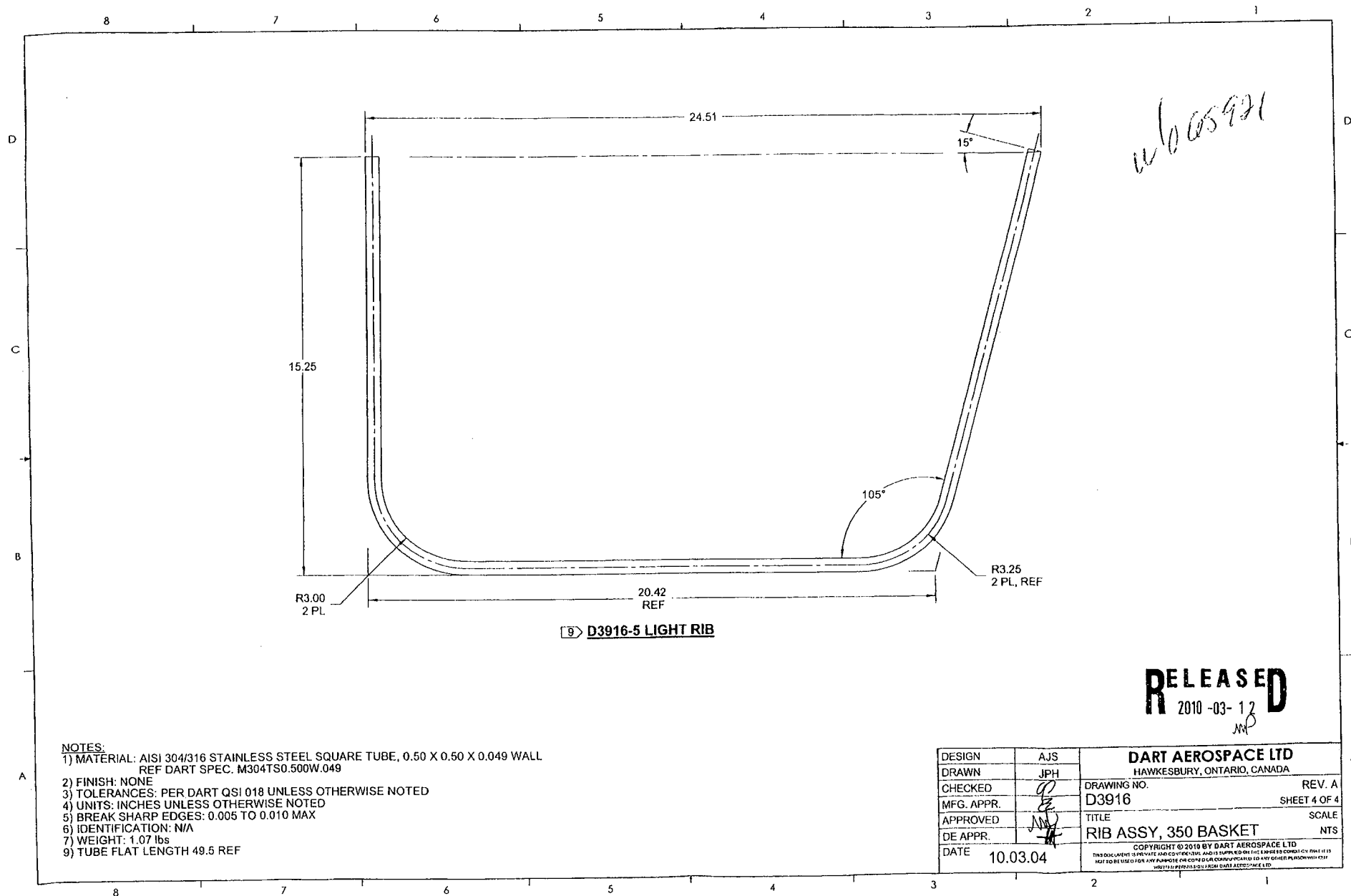
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**NOTE:** Date & initial all entries



**D3916-5 LIGHT RIB**

**RELEASED**  
2010-03-12  
JPH

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3916	REV. A SHEET 4 OF 4
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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